

Date: Monday, 02/03/2009 9:05:19 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 46150
Estimate Number : 10578
P.O. Number :
This Issue : 02/03/2009 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : MACHINED PARTS
Previous Run : 44791
Written By :
Checked & Approved By : JUD 09.03.02
Comment : A 05.09.27 New issue EC

Drawing Name : CLEVIS

Part Number : D34533

Drawing Number : D3453 REV A

Project Number : N/A

Drawing Revision : A

Material :

Due Date : 16/03/2009

Qty: 30 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M304R1250

304 round bar 1.250



Comment: Qty.: 0.2452 f(s)/Unit Total: 2.9424 f(s)

Material: AISI 304 SS Round Bar Ø1.250

(M304R1.250)

Batch: ~~4108156~~
4108156

mk 09/03/03

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA578 Rev: AA & Dwg D3453 Rev: A

2- Deburr as per dwg D3453

mk 09/03/03 / mk 09/03/03

30 pcs

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 09/03/03 / mk 09/03/03

30 pcs

4.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Mill as per Folio FA578 Rev: AA & Dwg D3453 Rev: A

2- Deburr as per dwg 3453

HA 09/03/05 / 88 09/03/04

PTO →

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HA 09/03/05 / 88 09/03/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3453-3 PAR #: N/A Fault Category: Pro Machined Part NCR: Yes No DQA: D Date: 09/03/10
 Resolution: Process Reused Disposition: Scrap QA: N/C Closed: D Date: 09/03/10

NCR: <u>46150</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/04	4.0	Two parts was scrap one the slot was off center the other one the slot was cracked. R.C. First part bad origin with a new setup. the other one had move in the Jig. So a return too had setup.	<u>AB</u>	Scrap no replace.	<u>AB</u> 09/03/04	<u>S</u> 07/03/05	<u>AB</u> 09/03/05	<u>S</u> 09/03/05

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 9:05:19 AM
Usér: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 46150

Part Number: D34533

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

HA 09/03/06

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SS 09/03/06

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 09/03/08

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Carl L.

SS 09/03/09

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/10

Job Completion



MF 09-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

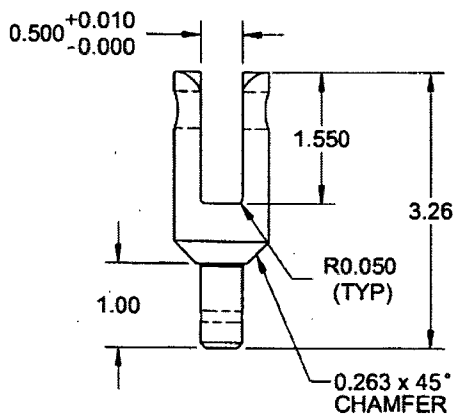
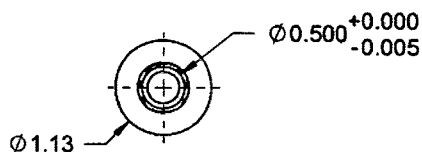
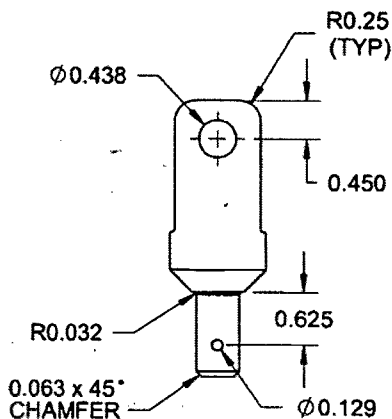
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



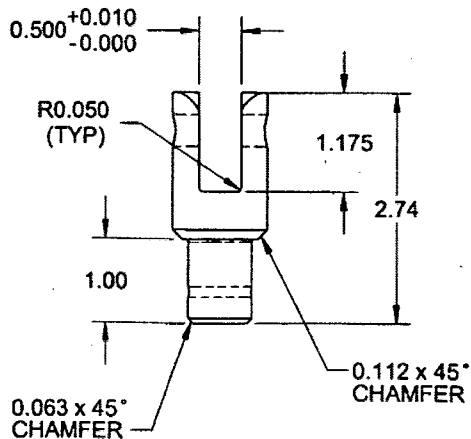
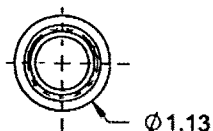
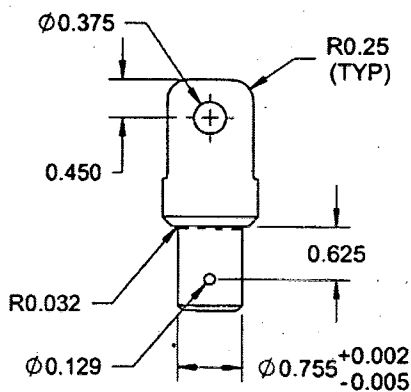
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3453	REV. A SHEET 1 OF 2
DATE 05.09.02		TITLE CLEVIS	SCALE 1:2
A	05.09.02	NEW ISSUE	



D3453-1 CLEVIS

RELEASED

05.12.09 *[Signature]*



D3453-3 CLEVIS

NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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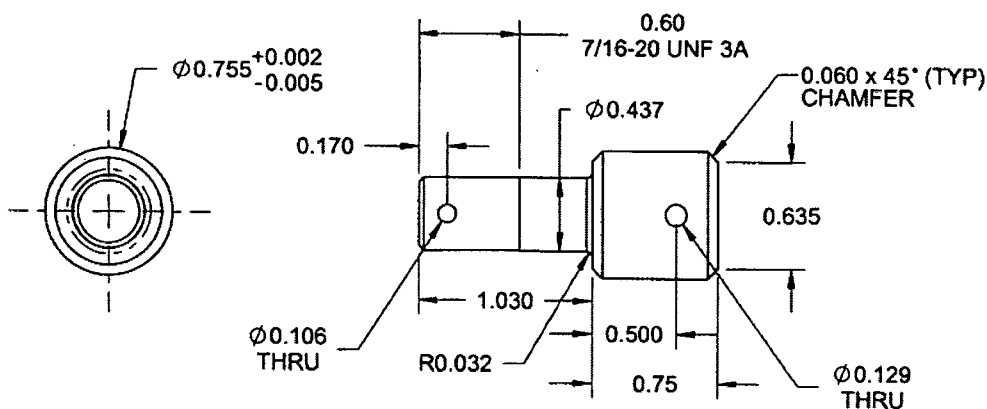
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CHECKED ##	APPROVED ##	DRAWING NO. D3453	REV. A SHEET 2 OF 2
DATE 05.09.02		TITLE CLEVIS	SCALE 1:1

RELEASED

05.12.09



D3453-5 PLUG

NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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